

Work Order ID 129621

129621

Ship monday Page 1

Friday, February 20, 2015 8:43:19 AM

Item ID: DSI 9689-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Wearplate Installation

Start Date: 2/20/2015 Start Qty: 1.00 *1*

Required Date: 2/23/2015 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: mf Date: 15-2-20 Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9689	A	<i>SP</i>				M F		15-02-20	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP DSI 9689-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

1x

DAS
46
9-89

FEB 23 2015

DAS
27
9-89

FEB 23 2015

DAS
28
9-89

1x

DAS
46
9-89

FEB 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 1

Friday, February 20, 2015 8:43:17 AM

Work Order ID: 129621

129621

Parent Item: DSI 9689-011

DSI 9689-011

Parent Item Name: Wearplate Installation

Start Date: 2/20/2015

Required Date: 2/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.05.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3859-041		Manufactured	No				Each	4.0000		2		DAS 27 9-89	
D3859-041									**			FEB 23 2015	DAS 28 9-89
Wearplate													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST613			4					
					128786			4					
D4011-1		Manufactured	No				Each	15.0000		6		DAS 27 9-89	
D4011-1									**			FEB 23 2015	DAS 28 9-89
Clamp, Short													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST542			15					
					113078			3					
					114217			2					
					119425			10					
D4012-1		Manufactured	No				Each	6.0000		6		DAS 27 9-89	
D4012-1									**	129619		FEB 23 2015	DAS 28 9-89
Cushion													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG			4					
					97172			4					
					ST545			2					
					119517			2					

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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Friday, February 20, 2015 8:43:18 AM

Work Order ID: 129621

Parent Item: DSI 9689-011

Parent Item Name: Wearplate Installation

129621

DSI 9689-011

Start Date: 2/20/2015

Required Date: 2/23/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

2,662.000

12

DAS
27

NAS1149D0463J

DAS

46

WASHER

9-89

FEB 23 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1151

M129390

1151

ST269

706

M130799

706

12

12

D3601-1

Manufactured

No

Each

118.0000

**

DAS
27

D3601-1

DAS

46

Radius Block

9-89

FEB 23 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

ST051

6

121690

6

ST051A

112

124090

112

6

6

6

12

AN4-16A

Purchased

No

Each

133.0000

**

DAS
27

AN4-16A

DAS

46

Bolt

9-89

FEB 23 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

128

M131139

28

M131420

100

12

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 3

Friday, February 20, 2015 8:43:18 AM

Work Order ID: 129621

129621

Parent Item: DSI 9689-011

DSI 9689-011

Parent Item Name: Wearplate Installation

Start Date: 2/20/2015

Required Date: 2/23/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

4,039.000

12

DAS

27

9-89

MS21042L4

DAS

46

9-89

Locknut

FEB 23 2015

Location

Loc Qty

Loc Code

FP001	42	
m124231	42	
GA	704	
m127813	704	
ST260a	1150	
m130799	66	
m131340	1084	
ST305	2143	
426	426	
m128300	8	
m128798	8	
m130922	101	
m131618	1600	

DAS

28

9-89

DQA: _____ Date: _____



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REFERENCE ONLY

DAS

46

9-89

FEB 23 2015

2.0 PROCEDURE

Install the D350-578-0XX Bearpaws using the DSI 9689-011 Clamp Kit as follows:

- 2.1 Locate a D3859-041 Wearplate Assy on the bottom side of each Bearpaw using the AN4-16A bolts.
- 2.2 Jack up the aircraft per the Aircraft Maintenance manual.
- 2.3 Position a Bearpaw complete with D3859-041 Wearplate Assy under the aft end of each skidtube as shown in Figure 1.
- 2.4 Lower the aircraft so the aircraft is sitting on the Bearpaws.
- 2.5 Install the Bearpaws using the hardware as shown in Figure 2.

CAUTION: The torque on the nuts should be limited to 20 in-lb (2.3Nm).

NOTE: Additional NAS1149D0463J washers may be installed under the nuts to ensure 1.5 - 4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-16A bolts with longer or shorter AN4 bolts, if required.

3.0 PARTS LIST:

QTY -011	P/N	DESCRIPTION
(X)	DSI 9689-011	CLAMP KIT
2	D3859-041	WEARPLATE ASSY
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	NAS1149D0463J	WASHER
12	D3801-1	RADIUS BLOCK
12	AN4-16A	BOLT
12	MS21042L4	NUT, SELF-LOCKING

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9689-011 Clamp Kit	3.0 lb 1.36 kg	0.0 in 0.0 m	0.0 lb-kq 0.0 m-kq	157.0 in 3.99 m	471 in-lb 5.43 m-kq

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 14.03.19
CERT. NO.: SH93-4
ISSUE NO.: 8

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO. DSI 9689	REV. A SHEET 2 OF 2
MFG. APPR.	N/A		
APPROVED		TITLE INSTALLATION MODIFICATION NTS	
DE APPR.			
DATE 14.03.19		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	